

Work Order ID 55339

January 13, 2010 10:26:55 AM



Page 1

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 1/13/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *RF*

Date: *10-1-13*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3508

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

RB 10-1-18

7

FLOW CNC Waterjet

1-Cut as per Dwg D3508 ☐ Dwg Rev: *C* ☐ Prog Rev: *C* ☐ 2-
Deburr if necessary

304. 040

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

RB 10-1-18

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

=> 51061/18

x6

Pho ->

Quality Control

W/O: 55339

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/18	#120	Took Qty x1 Part for QC inspection Template	S	10/1/18	4		

Part No: D3508-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 1/13/10 Start Qty: 6.00

Cust Item ID:

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Customer:

Reference:

Run Start

Approvals: Process Plan:

Date: Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Form on brake using DT8326 and DT8261 as per Dwg D350812-Form joggle as per Dwg D3508 Using DT8158

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME: 6:45am OVEN TEMPERATURE: 370°F
FINISH TIME: 7:15am

0.00

0.00

JB 10/01/19

→ S 10/01/20

⇒ JH 10/01/21

6

(X6)

(X6)

W/O:		WORK ORDER CHANGES					
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Work Order ID 55339

January 13, 2010 10:26:55 AM



Page 3

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 1/13/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

BL

10-01-21

6

0

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: EP-21

0.00

M

10-01-21

X6

0

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/21 JF

MF 10-1-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

January 13, 2010 10:27:00 AM

Work Order ID: 55339



Parent Item: D3508-3



Parent Item Name: Wearplate

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP Rev:A New Issue 06-06-20 JLM
 IPP Rev:B Now SS as per Rev B 06-12-15 JLM
 IPP Rev:C Rev C dwg 07-12-06 DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304S20GA		Purchased	No			100	sf	286.5294	4.6358			



304/316 .040 Sheet



5.4126

18 10-1-18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

286.5294053

110076

0.40253684

112567

38.0765789

112885

83.1578

113062

156.3723

113077

8.52018947

113062

7

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55339
Description: Wearplate		Part Number:	D3508-3
Inspection Dwg: D3508 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.068	✓			
2.813	+/-0.010	2.809	✓			
0.375	+/-0.010	.372	✓			
5.625	+/-0.010	5.625	✓			
33.750	+/-0.010	33.750	✓			
37.13	+/-0.030	37.125	✓			
Ø0.188	+0.005/-0.001	.191	✓			
0.300	+/-0.010	.302	✓			
0.300	+/-0.010	.305	✓			
0.038	+/-0.010	.036	✓			

Measured by: RB Date: 10-1-18	Audited by: S Date: 10/6/18	Prototype Approval: N/A Date: N/A
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Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

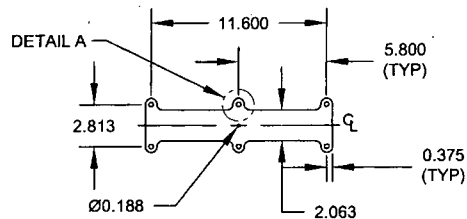
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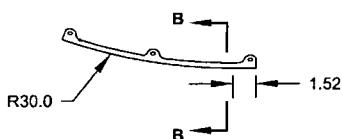
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WORK ORDER

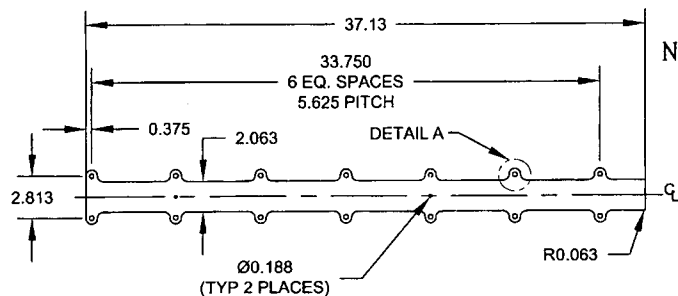
NO. 55339
P10-113



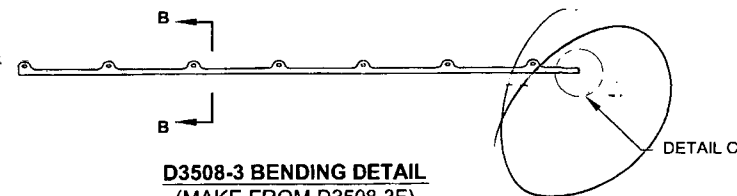
D3508-1 FLAT PATTERN



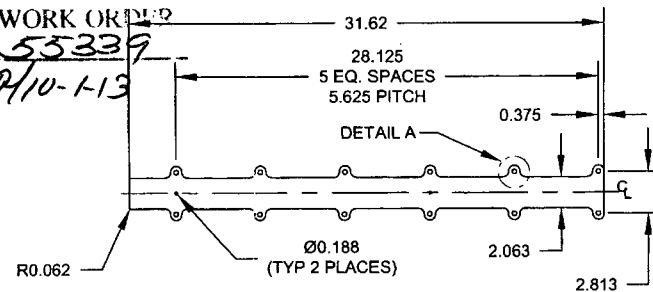
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



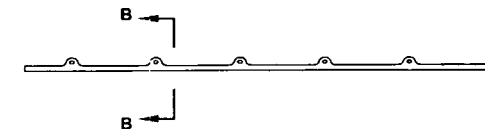
D3508-3 FLAT PATTERN



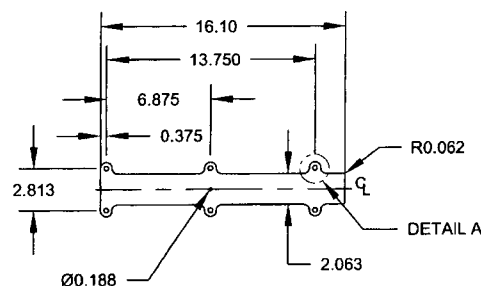
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



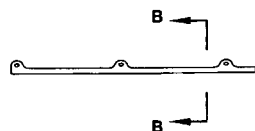
D3508-5 FLAT PATTERN



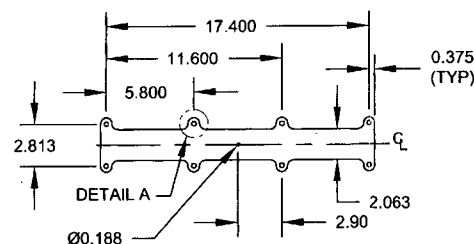
D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)



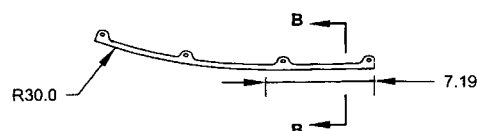
D3508-7F FLAT PATTERN



D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07.11.16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	244	DART AEROSPACE USA, INC	
DRAWN	244	PORT HADLOCK, WA	
CHECKED	244	DRAWING NO.	REV. C
MFG. APPR.	244	D3508	SHEET 1 OF 2
APPROVED	244	TITLE	SCALE
DE APPR.	244	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

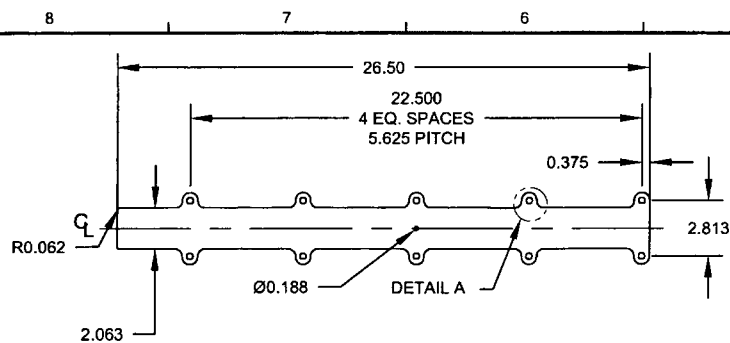
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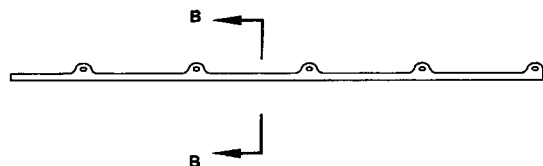
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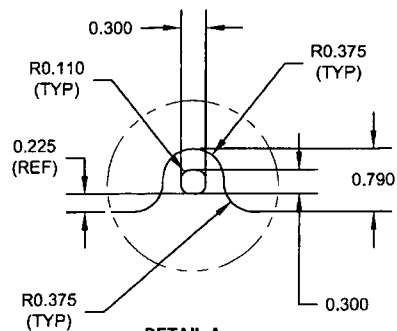
NOTE: Date & initial all entries



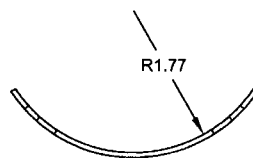
D3508-11F FLAT PATTERN



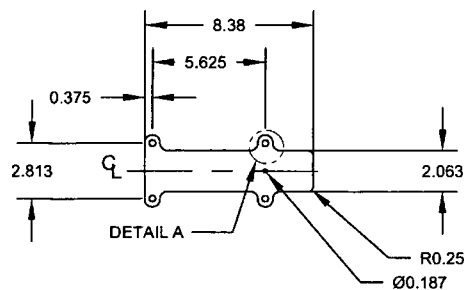
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



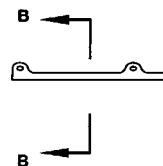
DETAIL A
(SCALE 2:3)



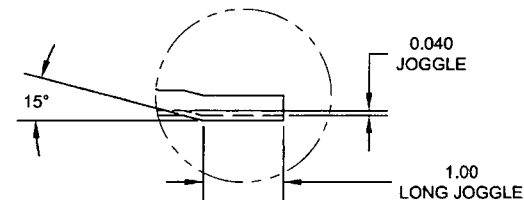
SECTION B-B
(SCALE 2:3)



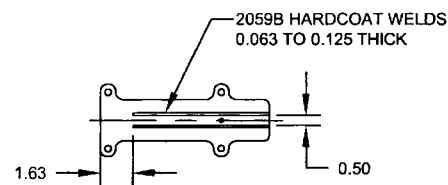
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASED
07-11-16

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